

Work Order ID 134694

Wednesday, July 15, 2015 12:00:10 PM

134694

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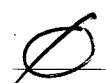
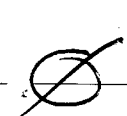
Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 7/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/15/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: JUL 15 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100 0.00
100 MORI SEIKI CNC LATHE LARGE
Mori Seiki Memo 0.02
Mori Seiki CNC Lathe Large Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: F
ensure steady rest is turning true
****REMOVE STEADY REST AND MACHINIG MARKS****

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
QC Memo 0.00
Quality Control

1 
manual
15/07/28
1 
manual
15/07/28

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Tube Assembly

Stop *NS2*

Start Date: 7/15/2015 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 7/15/2015 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

JUL 29 2015

120		0.01	
120	HAAS CNC VERTICAL MACHINING #1		DAS 20 9-89 15-08-26
HAAS 1	Memo	0.03	
HAAS CNC vertical machine #1	1-Machine as per Folio FA 599 Rev: <u>AN</u> & Dwg D3391 Rev: <u>I</u> 2-Deburr		

130	QC2- Inspect parts off machine FAI/FAIB	0.00	
130			
QC	Memo	0.00	DAS 20 9-89 15-08-26
Quality Control			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140									
QC	Memo	0.00							
Quality Control	***INSPECT INSIDE BORE***								
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160		0.00							
160	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								

15-9-1

15-9-1

15/08/31

DAS 14 9-89

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

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Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 7/15/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/15/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

180

Skidtubes

Skidtubes

Skidtubes

Memo

0.02

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

7-Deburr

8- Scribe batch # on fwd end

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			38 9-89 SEP 08 2015
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.01							 15-9-9
210 *210* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				1	0	15-09-09	DAS 18 9-89

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
220									
Skidtubes	Memo 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>131589</u> exp. date: <u>16-7-30</u> cure time 12hrs as per QSI0015	0.01							
	2- Grind crossbolts flush								
	3- Back drill using #9 drill								
	4- Touchup Magnabond								
	5- Deburr								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									

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15-9-10
15.09.10

DAS
9
9-89

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235	Pressure Wash per QSI005 4.3	0.00							
235									
HandFinish	Memo	0.01							
Hand Finishing	AND REALODINE AS PER PAR09-043								
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240	<i>m 131545</i>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>3:40</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>4:10</i>								
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00							
Quality Control									

1 0 15-9-14 DC

1 0 15-9-17 DAS 34 989

1 0 15/09/22 DAS 15 989

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Required Date: 7/15/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
260	HandFinish	0.01							
Hand Finishing	Memo 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 <u>M1136133</u> Sikaflex expiry date: <u>16/12</u> 3- INSTALL WEARPLATES AS PER DWG								
270	QC5- Inspect part completeness to step on W/O	0.00							
270	QC	0.00							
Quality Control	Memo								DAS 38 9-89 SEP 23 2015
280	Identify as per dwg & Stock Location: <u>wlb</u>	0.00							
280	Packaging	0.01							
Packaging	Memo								0412-742-043 / B135343 1x d M 15/09/22

16 d All 15/09/22

1 DAS 38 9-88 SEP 23 2015

0412-742-043 / B135343 1x d All 15/09/22

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Required Date: 7/15/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	QC21- Final Inspection - Work Order Release	0.00							
290									
QC	Memo	0.00							
Quality Control									

MCS SEP 23 2015

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D3391-025

Required Date: 7/15/2015

Required Qty: 1.00

Comments:	IPP Rev B	06-02-07	ECN773 dwg rev. D	EC	
	IPP Rev:C	06-03-28	Update Manuf. Instructions	JLM	
	IPP rev D	07.03.20	revF dwg	EC	
	IPP rev E	07.11.07	rev G dwg ecn 1053p	EC	verified by: DD
	IPP Rev:F	07-11-13	ECN 1056	DD	verified by: EC
	IPP Rev:G	08-09-10	revH as per dwg	DD	verified by:EC
	11.11.14 AS PER REV.I	DD	verified by:JLM		IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	11.0000	1	1			
D4095-047 Wearpad Aft													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				11					
					116100			7					
					<u>133502</u>			4					
D4095-049		Manufactured	No			260	Each	33.0000	1	1			
D4095-049 Wearpad Aft													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				33					
					<u>126331</u>			33					
D6014-090		Manufactured	No			100	Each	27.0000	1	1			
D6014-090 ALUMINUM EXTRUSION													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG003				27					
					79742			1					
					<u>86063</u>			26					

Picklist Print

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

16.0000

4

4

D3670-4-200

Bushing

**

15-9-9

Location

Loc Qty

Loc Code

FG

10

87709

10

LG002

134974

6

132777

6

4

D2646

Manufactured No

270

Each

62.0000

1

1

D2646

Aft Cap

**

11 12/04/22

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

58

103306

1

114495

1

127924

6

128761

2

132325

16

132326

32

X1

Picklist Print

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Work Order ID: 134694

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each 578.0000 2 2

D3672-1

Washer, Phenolic

lll 15/08/22

Location

Loc Qty

Loc Code

FG	10	
85222	10	
FP001	138	
113581	138	
ST055	430	
112218	72	
120116	3	
127322	355	

X2

ALS4-1032-130 AE4S4-1032-130 Purchased No

260 Each 1,213.000 14 14

AI S4-1032-130

Rivnut

lll 15/08/22

Location

Loc Qty

Loc Code

st549	1213	
M132317	1213	

11132077

X14

ALS4-1032-225 AE4S8-1032-225 Purchased No

270 Each 1,095.000 8 8

AI S4-1032-225

Rivnut

lll 15/09/22

Location

Loc Qty

Loc Code

FG	120	
M127028	120	
FP001	484	
M131582	484	
st549	491	
M131582	491	

X8

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

1,427.000

6

6

AN3C4A

Bolt

ll 15/09/22

Location

Loc Qty

Loc Code

FG

20

11132930

x6

122814

20

FP001

907

M132551

907

ST350

500

M132317

500

AN3C5A

Purchased

No

270

Each

501.0000

4

4

AN3C5A

Bolt

ll 15/09/22

Location

Loc Qty

Loc Code

FG

5

11132930

x5

122800

5

ST

56

121708

56

ST338a

440

M131803

40

M132640

400

Picklist Print

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 7/15/2015

Required Date: 7/15/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

270

Each

4,223.000

10

10

NAS1149C0332R

WASHER

all 15/09/22

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

257

m131618

257

ST271

1826

m129390

72

m132262

1754

110

DART AEROSPACE LTD		Work Order: 134694
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: I	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		tape	L6-11
3.500	+/-0.010	3.502	✓		vern	NCR-08
Ø3.200	+/-0.010	3.198	✓			
Ø3.750	+/-0.010	3.750	✓			
30° x 0.060 chamfer	+/-0.010	30° x .060	✓		↓	
88.93	+/-0.030	88.93	✓		tape	L6-11

Measured by: mml	Date: 15/07/23
Audited by: DAS 38	Date: JUL 24 2015

9-89 HAAS Section						
1.526	+0.000/-0.030	1.520	✓		SLO8	Vern
7.500	+/-0.010	7.497	✓		SLO1	Tape
27.750	+/-0.010	27.750	✓		"	
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.295	✓		SLO8	
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.515	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.485	✓			

Measured by: DAS 20 9-89	Date: 15-08-26
Audited by: DAS 14 9-89	Date: 15/08/31

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	

